



Dart Hawkesbury  
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**D3910-3**  
**Job Sheet 168178**



Part No: D3910-3

Job Qty: 6 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No                                                  | Operation       | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|--------------------------------------------------------|-----------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|                                                        |                 |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 145                                                    | Rework Start up | 6 Ea  | 11/23/17   | 11/23/17 | 0.00      | 0.00    | Start Up Handfinish   |           | 2017-11-15 JSL |
| 160                                                    | Powdercoat      | 6 pcs | 11/24/17   | 11/24/17 | 0.00      | 0.05    | Powdercoat1           |           | BR 1701 21.    |
| 170                                                    | QC              | 6 pcs | 11/24/17   | 11/24/17 | 0.00      | 0.00    | QC3                   |           | 38             |
| 180                                                    | Packaging       | 6 pcs | 11/24/17   | 11/24/17 | 0.00      | 0.00    | Packaging3            |           | 9-89           |
| 190                                                    | QC21-SA         | 6 Ea  | 11/24/17   | 11/24/17 | 0.00      | 0.00    | QC21                  |           |                |
| Part Op 160 - START TIME: 4:20 O.V.T. 320° FINISH 4:50 |                 |       |            |          |           |         |                       |           |                |
| Descriptions: 122878.                                  |                 |       |            |          |           |         |                       |           |                |
| NOV 27 2017                                            |                 |       |            |          |           |         |                       |           |                |

### Job Allocations

| Operation           | Component Part  | Required | Inventory | Allocated | Std Qty |
|---------------------|-----------------|----------|-----------|-----------|---------|
| 145-Rework Start up | D3910-3 3008833 | 6        | 58        | 0         | 0       |

### Part Specifications

| Spec No | Description   | Target/Tolerance    | Limits         | Type      | Special Comments |
|---------|---------------|---------------------|----------------|-----------|------------------|
| 1       | Crosstube Lug | 4.450Inches ± 0.030 | 4.480<br>4.420 |           |                  |
| 2       | Crosstube Lug | 1.380Inches ± 0.030 | 1.410<br>1.350 |           |                  |
| 3       | Crosstube Lug | 0.080Inches ± 0.020 | 0.100<br>0.060 | Radius    |                  |
| 4       | Crosstube Lug | 0.270Inches ± 0.030 | 0.300<br>0.240 | reference |                  |
| 5       | Crosstube Lug | 0.310Inches ± 0.030 | 0.340<br>0.280 |           |                  |
| 6       | Crosstube Lug | 0.735Inches ± 0.010 | 0.745<br>0.725 | reference |                  |
| 7       | Crosstube Lug | 1.200Inches ± 0.030 | 1.230<br>1.170 | Radius    |                  |
| 8       | Crosstube Lug | 3.700Inches ± 0.010 | 3.710<br>3.690 |           |                  |
| 9       | Crosstube Lug | 0.375Inches ± 0.010 | 0.385<br>0.365 |           |                  |
| 10      | Crosstube Lug | 0.625Inches ± 0.010 | 0.635          |           |                  |

**DART**  
AEROSPACE  
**SU10192**



Crosstube Lug

**PART NO:**  
**Revision:**  
**Operation:**  
**Change No:**

**D3910-3**

**Rework Start up**

**Mfg Date: 11/15/17**  
**Job No: 168178**

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|    |               |                                                              |                  |           |
|----|---------------|--------------------------------------------------------------|------------------|-----------|
|    |               |                                                              | 0.615            |           |
| 1  | Crosstube Lug | 0.375Inches $\pm$ 0.010                                      | 0.385<br>0.365   |           |
| 12 | Crosstube Lug | 0.340Inches $\pm$ 0.030                                      | 0.370<br>0.310   | Radius    |
| 13 | Crosstube Lug | 0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$ | 0.263<br>0.256   | Diameter  |
| 14 | Crosstube Lug | 0.100Inches $\pm$ 0.010                                      | 0.110<br>0.090   |           |
| 15 | Crosstube Lug | 45.000Degrees $\pm$ 0.500                                    | 45.500<br>44.500 | angle     |
| 16 | Crosstube Lug | 1.410Inches $\pm$ 0.030                                      | 1.440<br>1.380   | Reference |

Plex 11/10/17 12:55 PM dart.poulin.mario